

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 40693

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

NAS1149F0332P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

WASHER

batch: 18057

18-08-08

21.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

18-08-08

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18-08-23

(XO)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and ~~Stink~~

Location: *cored welding*

18-08-23

24.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mt 08-10-23

Process Sheet

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Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 40693

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001267

PB67-43001-267



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

PB67-43001-267

batch: 340095

14.0

PB6743001121

Square Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Square Sleeve

batch: 340612

15.0

BSP43

RIVET



Comment: Qty.: 6.0000 Each(s)/Unit Total: 30.0000 Each(s)

RIVET

batch: 17890

16.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

PIN, QUICK RELEASE

batch: 108826

17.0

30345T21

LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

LANYARD

batch: 102812

18.0

MS27039122

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

SCREW

batch: 18057

19.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut

batch: 108814

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 40693

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W --



Comment: Qty.: 0.1575 f(s)/Unit Total: 0.7875 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: M 18/88

SP 08-07-31 - 08-08-06

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg

PB67-43001

NOT READ THIS BATCH ONLY TO AVOID CRACKING

SP 08-08-01 (4X)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08-08-01 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/07 (40)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1

08/08/08

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 102316

(4X)

(4X)

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15
320 °F
9:45

M-1

08/08/08

12.0

QC3

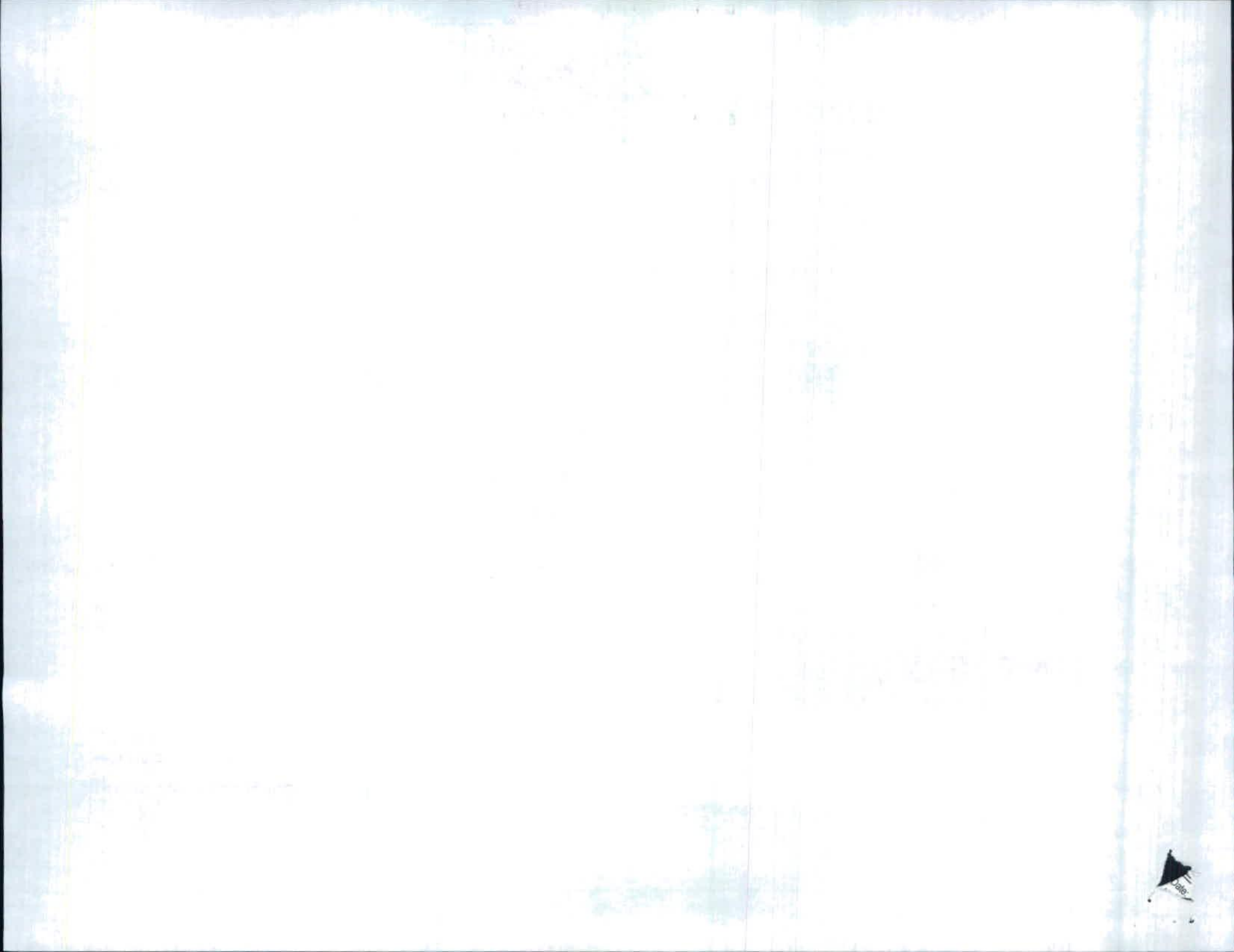
INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-08

(4X)



Tuesday, 22/07/2008 8:49:18 AM
Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ADJUSTABLE ATTACHMENT ARM ASSY
 Job Number : 40693 *Split*
 Estimate Number : 13479
 P.O. Number :
 This Issue : 22/07/2008 S.O. No. :
 Prsht Rev. : NC Part Number : PB674300159
 First Issue : 11 Type : LARGE FAB ASSY Drawing Number : B6743001 P.14
 Previous Run : Drawing Revision : B1
 Written By : Due Date : 29/07/2008 Qty: Um: Each
 Checked & Approved By : *MF 08-07-23*
 Comment : Est Rev:A 08-07-18 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001113 Square Tubing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Square Tubing

batch: *B40599 X3 SP 8-10-31 X1* (4X)

2.0 PB6743001119 End Cap Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

End Cap Clevis

batch: *B40016 SP 08-07-31* (4X)

3.0 PB6743001117 Hook Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Hook Plate

batch: *B40015 SP 08-07-31* (4X)

4.0 PB6743001115 Tube End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Tube End Plate

batch: *B40014 SP 08-07-31* (4X)

5.0 PB6743001271 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Doubler

batch: *B40058 SP 08-08-6* (8X)